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3, rue de la Harpe, CH-1015, Yverdon, Suisse  
P.O. Box 68, CH-1015, Yverdon, Suisse  
Tel. (41) 26 30 61 11, Fax (41) 26 30 61 21  
E-mail: info@wipo.int, internet@wipo.int

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(71) Applicant: **CHEVRON PHILLIPS CHEMICAL  
COMPANY LP** [US/US]; 10001 Six Pines Drive, The  
Woodlands, TX 77380 (US).

(72) Inventors: **SWISHER, Gregory, M.**; 508 Dorsett Ct.,  
Bartlesville, OK 74006 (US). **RHODES, Vergil, H., Jr.**;  
3919 Silver Lake View, Bartlesville, OK 74006 (US).  
**STACY, Nathan, E.**; 2306 London Lane, Bartlesville,  
OK 74006 (US). **DEPORTER, Craig, D.**; 503 Downing  
Street, Denver, CO 80218 (US). **MOCZYGEMBA,  
George, A.**; 3304 SE Kinsington Ct., Bartlesville, OK  
74006 (US).

(74) Agent: **HULETT, Joe, E.**; Chevron Phillips Chemical  
Company LP, 10001 Six Pines Drive, The Woodlands, TX  
77380 (US).

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**WO 03/099925 A1**

(54) Title: CONJUGATED DIENE/MONOVINYLAENE BLOCK COPOLYMERS BLENDS

(57) Abstract: This invention relates to polymer blends, which comprise at least one tapered conjugated diene-monovinylarene block copolymer and at least one styrenic polymer. The polymer blends possess good optical and mechanical properties.

## CONJUGATED DIENE/MONOVINYLARENE BLOCK COPOLYMERS BLENDS

This application is a continuation-in-part application of 09/576,879, now allowed, which is a divisional application of 08/521,335, now US 6,096,828 and  
5 application 09/576,408, now allowed.

### FIELD OF INVENTION

This invention relates to polymer blends comprising at least one tapered conjugated diene/monovinylarene block copolymer and at least one styrenic polymer.

### BACKGROUND OF THE INVENTION

10 Copolymers of conjugated diene/monovinylarene are known and useful for a variety of purposes. Of particular interest are polymers that can be formed into colorless, transparent articles having good physical properties, such as impact resistance. Such articles are useful in toys, window pieces, beverage containers, and packaging such as blister packaging.

15 The polymers should also exhibit sufficient thermal stability to be suitable for use with conventional injection molding equipment. For many applications copolymer blends containing high amounts of styrene are required. Such polymers are generally prepared by blending certain monovinylarene-conjugated diene copolymers with styrene polymers. However such blends often contain an  
20 undesirable haze and blue coloration. It would therefore be desirable to develop polymers and polymer blends having a combination of low blueness, good clarity, hardness, stiffness, and toughness.

### SUMMARY OF THE INVENTION

It is an object of this invention to provide a polymer useful for preparing  
25 blends having good optical clarity.

It is another object of this invention to provide a process for preparing such polymers having good optical and mechanical properties.

In accordance with this invention a block copolymer comprising at least three consecutive conjugated diene/monovinylarene tapered blocks is provided. As used

herein, consecutive means three sequential tapered blocks with no intervening homopolymer blocks. The tapered blocks contain a mixture of monovinylarene and conjugated diene.

In accordance with another aspect of this invention, a polymer blend  
5 comprises at least one coupled conjugated diene/monovinylarene block copolymer and at least one styrenic polymer, wherein the coupled conjugated diene/monovinylarene block copolymer is produced by a process comprising sequentially contacting under polymerization conditions at least one monovinylarene monomer, an organoalkali metal initiator, at least one conjugated diene monomer, and  
10 thereafter coupling with a polyfunctional coupling agent to form the block copolymer; at least three consecutive monomer mixture charges containing monovinylarene monomer and conjugated diene monomer are provided to produce at least three consecutive conjugated diene/monovinylarene tapered blocks in the block copolymer; all the monovinylarene monomer and conjugated diene monomer contained in each  
15 charge are added at the beginning of the charge allowing excess of monomer to be present in the reactor; the at least one monovinylarene monomer contains from 8 to 18 carbon atoms, and the at least one conjugated diene monomer contains from 4 to 12 carbon atoms, and the styrenic polymer is selected from the group consisting of at least one copolymer produced by copolymerizing at least one styrenic co-monomer  
20 and at least one unsaturated oxygen or nitrogen containing co-monomer.

In yet another aspect of the present invention, the styrenic polymer (excluding styrene homopolymers) is selected from the group consisting of at least one copolymer produced by copolymerizing at least one styrenic co-monomer and at least one unsaturated oxygen or nitrogen containing co-monomer, wherein the polymer  
25 blend comprises 60 wt% or more of the coupled conjugated diene/monovinylarene block copolymer; the monovinylarene monomer is selected from the group consisting of styrene, 2-methylstyrene 3-methylstyrene, 4-methylstyrene, 4-ethylstyrene, 4-t-butylstyrene,  $\alpha$ -methylstyrene, and mixtures thereof; the conjugated diene monomer is selected from butadiene, isoprene, 2,3-dimethylbutadiene; the styrenic co-monomer is  
30 selected from the group consisting of styrene, 2-methylstyrene 3-methylstyrene, 4-methylstyrene, 4-ethylstyrene, 4-t-butylstyrene,  $\alpha$ -methylstyrene, and mixtures thereof; and the unsaturated oxygen or nitrogen containing co-monomer is selected

from the group consisting of methyl acrylate, ethyl methacrylate, methyl acrylate, ethyl methacrylate, glycidyl acrylate, glycidyl methacrylate, acrylonitrile, and mixtures thereof.

#### DETAILED DESCRIPTION OF THE INVENTION

5           The basic starting materials and polymerization conditions for preparing conjugated diene/monovinylarene block copolymer are disclosed in U.S. Pat. Nos. 4,091,053; 4,584,346; 4,704,434; 4,704,435; and 5,227,419; the disclosures of which are hereby incorporated by reference.

10           Suitable conjugated dienes which can be used in the block copolymers include those having 4 to 12 carbon atoms per molecule, with those having 4 to 8 carbon atoms preferred. Examples of such suitable compounds include 1,3-butadiene, 2-methyl-1,3-butadiene, 2-ethyl-1,3-butadiene, 2,3-dimethyl-1,3-butadiene, 1,3-pentadiene, 3-butyl-1,3-octadiene, and mixtures thereof. The preferred dienes are 1,3-butadiene and isoprene, more preferably 1,3-butadiene.

15           Suitable monovinylarene compounds which can be used in the block copolymers include those having 8 to 18 carbon atoms per molecule, preferably 8 to 12 carbon atoms. Examples of such suitable compounds include styrene, alpha-methylstyrene, 2-methylstyrene, 3-methylstyrene, 4-methylstyrene, 2-ethylstyrene, 3-ethylstyrene, 4-ethylstyrene, 4-n-propylstyrene, 4-t-butylstyrene, 2,4-dimethylstyrene, 20 4-cyclohexylstyrene, 4-decylstyrene, 2-ethyl-4-benzylstyrene, 4-(4-phenyl-n-butyl)styrene, 1-vinylnaphthalene, 2-vinylnaphthalene, and mixtures thereof. Styrene is the preferred monovinylarene compound.

          The relative amount of conjugated diene and monovinylarene in the block copolymer can vary broadly depending on the particular characteristics desired.

25           Generally, the conjugated diene/monovinylarene block copolymer will contain monovinylarene monomer in an amount in the range of from about 55 weight percent to about 95 weight percent based on the total weight of the final block copolymer, preferably in the range of from about 60 weight percent to about 95 weight percent, and more preferably in the range of from 65 weight percent to 90 weight percent.

30           Generally the conjugated diene monomer will be present in the final block copolymer in an amount in the range of from about 45 weight percent to about 5

weight percent based on the total weight of the final block copolymer, preferably in the range of from about 40 weight percent to about 5 weight percent, and more preferably in the range of from 35 weight percent to 10 weight percent.

At least one of the tapered block copolymer used to prepare the polymer blend  
5 of the present invention contains at least three consecutive conjugated diene/monovinylarene tapered blocks, which are incorporated sequentially into the block copolymer with no intervening homopolymer blocks.

The amount of each monomer in the tapered block can vary broadly depending on the particular characteristics desired. Generally monovinylarene will be present in  
10 each tapered block in an amount in the range of from about one weight percent to about 20 weight percent based on the total weight of the final block copolymer, preferably from about 2 weight percent to about 15 weight percent.

Generally the conjugated diene will be present in each tapered block in an amount in the range of from about one weight percent to about 15 weight percent  
15 based on the total weight of the final block copolymer, preferably from about 2 weight percent to about 12 weight percent. It is especially preferred that all conjugated diene monomer present in the final block copolymer be incorporated into the tapered blocks.

The relative amount of each monomer in the tapered block can also vary  
20 broadly depending on the particular characteristics desired. Generally the conjugated diene will be present in each tapered block in an amount in the range of from about 0.1 parts to about 10 parts per part monovinylarene in the tapered block, preferably from about 0.2 parts to about 5 parts per part monovinylarene.

The monomer and monomer mixtures are copolymerized sequentially in the  
25 presence of an initiator. The initiators can be any of the organomonoalkali metal compounds known for such purposes. Preferably employed are compounds of the formula RM, wherein R is an alkyl, cycloalkyl, or aryl radical containing 4 to 8 carbon atoms, more preferably R is an alkyl radical. M is an alkali metal, preferably lithium. A preferred initiator is n-butyl lithium.

30 The amount of initiator employed depends upon the desired polymer or incremental block molecular weight, as is known in the art, and is readily

determinable, making due allowance for traces of poisons in the feed streams. Generally the initiator will be present in an amount in the range of from about 0.01 phm (parts by weight per hundred parts by weight of total monomer) to about 1.0 phm, preferably about 0.01 phm to about 0.5 phm, and more preferably from 0.01  
5 phm to 0.2 phm.

Small amounts of polar organic compounds, such as ethers, thioethers, and tertiary amines can be employed in the hydrocarbon diluent to improve the effectiveness of the initiator and to randomize at least part of the monovinylarene monomer in a mixed monomer charge. Tetrahydrofuran is preferred. When  
10 employed, the polar organic compound is present in an amount sufficient to improve the effectiveness of the initiator. For example, when employing tetrahydrofuran to improve the effectiveness of the initiator, the tetrahydrofuran is generally present in an amount in the range of from about 0.01 to about 1.0 phm, preferably from about 0.02 to about 1.0 phm.

The polymerization process is carried out in a hydrocarbon diluent at any  
15 suitable temperature in the range of from about -100° C. to about 150° C, preferably from about 0° to about 150° C., at pressures sufficient to maintain the reaction mixture substantially in the liquid phase. Preferred hydrocarbon diluents include linear or cycloparaffins or mixtures thereof. Typical examples include pentane, hexane,  
20 octane, cyclopentane, cyclohexane, and mixtures thereof. Cyclohexane is presently preferred. The polymerization is carried out in a substantial absence of oxygen and water, preferably under an inert gas atmosphere.

Each monomer charge or monomer mixture charge is polymerized under solution polymerization conditions such that the polymerization of each monomer  
25 charge or monomer mixture charge is substantially complete before charging a subsequent charge.

Typical initiator, monomer and monomer mixture charge sequences include, but are not limited to the following:

#### Mode A

- 30 (a) monovinylarene monomer and initiator,  
(b) monovinylarene monomer and initiator,

- (c) conjugated diene/monovinylarene monomer mixture,
- (d) conjugated diene/monovinylarene monomer mixture,
- (e) conjugated diene/monovinylarene monomer mixture, and
- (f) coupling agent;

**5 Mode B**

- (a) monovinylarene monomer and initiator,
- (b) monovinylarene monomer and initiator,
- (c) conjugated diene/monovinylarene monomer mixture,
- (d) conjugated diene/monovinylarene monomer mixture,
- 10 (e) conjugated diene/monovinylarene monomer mixture,
- (f) conjugated diene/monovinylarene monomer mixture, and
- (g) coupling agent;

**Mode C**

- (a) monovinylarene monomer and initiator,
- 15 (b) monovinylarene monomer and initiator,
- (c) conjugated diene/monovinylarene monomer mixture,
- (d) conjugated diene/monovinylarene monomer mixture,
- (e) conjugated diene/monovinylarene monomer mixture,
- (f) conjugated diene/monovinylarene monomer mixture,
- 20 (g) conjugated diene/monovinylarene monomer mixture, and
- (h) coupling agent.

**Mode D**

- (a) monovinylarene monomer and initiator,
- (b) conjugated diene/monovinylarene monomer mixture and initiator,
- 25 (c) conjugated diene/monovinylarene monomer mixture,

- (d) conjugated diene/monovinylarene monomer mixture, and
- (e) coupling agent;

**Mode E**

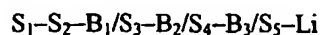
- (a) monovinylarene monomer and initiator,
- 5 (b) conjugated diene/monovinylarene monomer mixture and initiator,
- (c) conjugated diene/monovinylarene monomer mixture,
- (d) conjugated diene/monovinylarene monomer mixture,
- (e) conjugated diene/monovinylarene monomer mixture, and
- (f) coupling agent;

10 **Mode F**

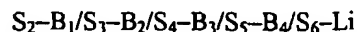
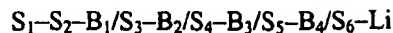
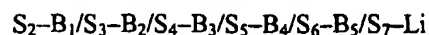
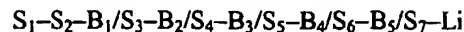
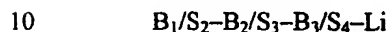
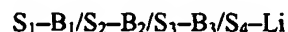
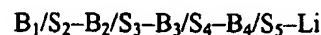
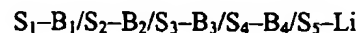
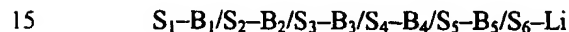
- (a) monovinylarene monomer and initiator,
- (b) conjugated diene/monovinylarene monomer mixture and initiator,
- (c) conjugated diene/monovinylarene monomer mixture,
- (d) conjugated diene/monovinylarene monomer mixture,
- 15 (e) conjugated diene/monovinylarene monomer mixture,
- (f) conjugated diene/monovinylarene monomer mixture, and
- (g) coupling agent.

The monomer mixture can be premixed and charged as a mixture or the monomers can be charged simultaneously. In step (a) the initiator can be added  
20 before or after the monovinylarene monomer charge. In large scale operations it may be desirable to add the monovinylarene monomer before adding the initiator in step (a). In subsequent steps containing initiator, the initiator should be added prior to the monomer or monomer mixture.

Prior to coupling, typical polymer chains prepared by the above described  
25 sequential polymerizations include the following:

**Mode A**



**Mode B**5 **Mode C****Mode D****Mode E****Mode F**

where "S" is a monovinylarene block, "B/S" is a tapered block containing a mixture of monovinylarene and conjugated diene "B", and "Li" is cationic residue from an alkali metal initiator.

- 20 The coupling agent is added after polymerization is complete. Suitable coupling agents include the di- or multivinylarene compounds, di- or multiepoxides, di- or multiisocyanates, di- or multiimines, di- or multialdehydes, di- or multiketones, alkoxytin compounds, di- or multihalides, particularly silicon halides and halosilanes, mono-, di-, or multianhydrides, di-, or multiesters, preferably the esters of
- 25 monoalcohols with polycarboxylic acids, diesters which are esters of monohydric alcohols with dicarboxylic acids, diesters which are esters of monobasic acids with polyalcohols such as glycerol, and the like, and mixtures of two or more such compounds.

Useful multifunctional coupling agents include epoxidized vegetable oils such as epoxidized soybean oil, epoxidized linseed oil and the like or mixtures thereof. The presently preferred coupling agent is epoxidized vegetable oil. Presently preferred is epoxidized soybean oil.

5 Any effective amount of the coupling agent can be employed. While the amount is not believed to be critical, generally a stoichiometric amount relative to the active polymer alkali metal tends to promote maximum coupling. However, more or less than stoichiometric amounts can be used for varying coupling efficiency where desired for particular products. Typically the total amount of coupling agent  
10 employed in the polymerization is in the range of from about 0.1 phm to about 20 phm, preferably from about 0.1 phm to about 5 phm, and more preferably 0.1 phm to 2 phm.

Following completion of the coupling reaction, the polymerization reaction mixture can be treated with a terminating agent such as water, alcohol, phenols or  
15 linear saturated aliphatic mono-dicarboxylic acids to remove alkali metal from the block copolymer and for color control. The preferred terminating agent is water and carbon dioxide.

The polymer cement (polymer in polymerization solvent) usually contains about 10 to 40 weight percent solids, more usually 20 to 35 weight percent solids.  
20 The polymer cement can be flashed to evaporate a portion of the solvent so as to increase the solids content to a concentration of about 50 to about 99 weight percent solids, followed by vacuum oven or devolatilizing extruder drying to remove the remaining solvent.

The block copolymer can be recovered and worked into the desired shape,  
25 such as by milling, extrusion, or injection molding. The tapered block copolymer can also contain additives such as antioxidants, antiblocking agents, release agents, fillers, extenders, and dyes, and the like as long as the amounts and types do not interfere with the objectives of this invention.

In another embodiment of this invention, the block copolymers are blended  
30 with other styrenic polymers such as polystyrene, acrylonitrile-butadiene-styrene copolymers, and styrene-acrylonitrile copolymers.

The styrenic polymers are usually (a) homopolymers of styrene; or (b) copolymers of styrene as a major component with a minor amount of any other copolymerizable monovinylarene compound other than styrene, such as alpha-methylstyrene, vinyltoluene or para-tert-butyl styrene. A minor amount of other  
5 monomers such as methyl acrylate, methyl methacrylate, acrylonitrile and the like can be copolymerized with the styrene. Blends comprising the inventive block copolymers and polystyrene exhibit a combination of desirable characteristics and they are preferred.

Preferred styrenic polymers for the present invention include copolymers  
10 having at least one styreneic co-monomer and at least one unsaturated oxygen or nitrogen (heteroatom) containing co-monomer.

Preferred styrenic co-monomer is selected from those having 8 to 18 carbon atoms per molecule, preferably 8 to 12 carbon atoms. Examples of such suitable co-monomers include styrene,  $\alpha$ -methylstyrene, 2-methylstyrene, 3-methylstyrene, 4-methylstyrene, 2-ethylstyrene, 3-ethylstyrene, 4-ethylstyrene, 4-n-propylstyrene, 4-t-butylstyrene, 2,4-dimethylstyrene, 4-cyclohexylstyrene, 4-decylstyrene, 2-ethyl-4-benzylstyrene, 4-(4-phenyl-n-butyl)styrene, 1-vinylnaphthalene, 2-vinylnaphthalene, and mixtures thereof. Styrene is a more preferred co-monomer.

Oxygen or nitrogen containing co-monomer includes carboxyl group-  
20 containing unsaturated monomers such as acrylic acid, methacrylic acid, crotonic acid, itaconic acid, maleic acid, fumaric acid, and the like (preferably methacrylic acid), C<sub>2-8</sub> hydroxyl alkyl esters of (meth)acrylic acid (preferably methacrylic acid) such as 2-hydroxyethyl (meth)acrylate, 2-hydroxypropyl (meth)acrylate, 3-hydroxypropyl (meth)acrylate, hydroxybutyl (meth)acrylate and the like,  
25 monomesters between a polyether polyol (e.g., polyethylene glycol, polypropylene glycol or polybutylene glycol) and an unsaturated carboxylic acid (preferably methacrylic acid); monoethers between a polyether polyol (e.g., polyethylene glycol, polypropylene glycol or polybutylene glycol) and a hydroxyl group-containing unsaturated monomers (e.g., 2-hydroxyl methacrylate); adducts between an  
30 unsaturated carboxylic acid and a monoepoxy compound; adducts between glycidyl (meth)acrylates (preferably methacrylate) and a monobasic acid (e.g., acetic acid, propionic acid, p-t-butylbenzoic acid or a fatty acid); monoesters or diesters between

- an acid anhydride group-containing unsaturated compounds (e.g., maleic anhydride or itaconic anhydride) and a glycol (e.g. ethylene glycol, 1,6-hexaediol or neopentyl glycol); chlorine-, bromine-, fluorine-, and hydroxyl group containing monomers such as 3-chloro-2-hydroxypropyl (meth)acrylate (preferably methacrylate) and the like;
- 5 C.sub.1-24 alkyl esters or cycloalkyl esters of (meth)acrylic acid (preferably methacrylic acid), such as methyl methacrylate, ethyl methacrylate, propyl methacrylate, isopropyl methacrylate, n-, sec-, or t- butyl methacrylate, hexyl methacrylate, 2-ethylhexyl methacrylate, octyl methacrylate, decyl methacrylate, lauryl methacrylate, stearyl methacrylate, cyclohexyl methacrylate and the like, C<sub>2-8</sub>
- 10 alkoxyalkyl esters of (meth)acrylic acid (preferably methacrylic acid), such as methoxybutyl methacrylate, methoxyethyl methacrylate, ethoxyethyl methacrylate, ethoxybutyl methacrylate and the like; polymerizable amides such as (meth)acrylamide, N-methyl(meth)acrylamide, (meth)acrylonitrile, and the like; glycidyl group-containing vinyl monomers such as glycidyl (meth)acrylates. All
- 15 these monomers can be used singly or as admixture of two or more than two.

The styrenic polymers and copolymers can be prepared by any method known in the art. The styrenic polymers are commonly prepared by heating styrene and any comonomer at temperatures in the range of from about 100°C to about 200°C and under pressure sufficient to polymerize the monomers. The polymerization can also

20 be carried out at lower temperatures by the addition of free radical generating peroxide catalysts such as benzoyl peroxide, acetyl peroxide, di-t-butyl peroxide and the like. Alternatively, the polymerization can be carried out in suspension to yield a dry powder or in emulsion, usually resulting in a latex of polystyrene which can be coagulated to yield the solid powdery polystyrene. The polymerization can also be

25 carried out in solution with precipitation of the product. Solvent can be removed by standard techniques such as steam stripping or solvent evaporation.

High impact polystyrene can also be employed in blends with the inventive block copolymers. High impact polystyrenes can be prepared by polymerizing styrene in the presence of elastomer, typically polybutadiene rubber.

30 The relative amounts of tapered block copolymer and styrenic polymer employed in preparing the polymer blend can vary broadly depending on the desired characteristics of the final polymer blend. Typical polymer blends contain block

copolymer in an amount in the range of from about 5 weight percent to about 95 weight percent based on the total weight of the final polymer blend, preferably from about 10 weight percent to about 90 weight percent, and more preferably from about 20 weight percent to about 80 weight percent based on the total weight of the final polymer blend.

The styrenic polymer will be present in an amount in the range of from about 5 weight percent to about 95 weight percent based on the total weight of the final polymer blend, preferably from about 10 weight percent to about 90 weight percent, and more preferably from about 20 weight percent to about 80 weight percent based on the total weight of the final polymer blend.

When at least one of the preferred styrenic polymers, *i.e.* those produced by copolymerizing at least one styrenic co-monomer and at least one unsaturated heteroatom (such as oxygen or nitrogen) containing co-monomer is used, it is preferred to have 50wt% (based on total weight of the final polymer blend) or less of such a styrenic polymer in the polymer blend. It is thus preferred to have 50 wt% or more, more preferably 60 wt% or more, most preferably 70 wt% or more of at least one triple (three consecutive) tapered block copolymer in the blend. It is within the present invention to have other single, double, triple or higher-level tapered block copolymers in the polymer blend. Non-tapered block copolymers can also be blended into the final product.

The polymer blends described above exhibit a combination of desirable characteristics. The polymer blends exhibit haze of less than about 15 percent, preferably less than about 10 percent measured according to ASTM 1003, using test specimens of 50 mil thickness and an instrument such as a Gardner Hazemeter. When using test specimens of 15 mil thickness and an instrument such as a HunterLab ColorQuest, preferably the haze will be less than 5 percent.

The polymer blends preferably exhibit a Notched Izod Impact Strength of greater than about 0.2 ft-lb/inch, preferably greater than 0.3 ft-lb/inch, more preferably greater than about 0.4 ft-lb/in, measured according to ASTM D-256.

The polymer blends also exhibit low blueness, preferably having an absolute number for blueness of less than 20, measured with a HunterLab D25 M Optical

Sensor using three stacked injection molded (350°F/30 tons/2 minutes) resin disks of 50 mil thickness measured against a calibrated black background. Positive numbers represent yellow and negative numbers represent blue. When employing 15 mil thick extruded sheet (400° F./20 mil nominal die gap), the absolute number for blueness  
5 will preferably be less than 15, more preferably less than 5.

Blending can be accomplished by any method known in the art including melt blending and solution blending. Preferably the polymers are melt blended employing any desired means such as a Banbury mixer, a hot roll, or an extruder. More preferably the polymers are melt blended employing extruder blending techniques.  
10 Single or twin screw extruders can be utilized. The polymers and any other ingredients or additives can be dry blended prior to the melt blending.

The blending conditions depend upon the blending technique and polymers employed. If an initial dry blending of the polymer is employed, the dry blending conditions may include temperatures from room temperature up to just under the  
15 melting temperature of the polymer, and blending times in the range of a few seconds to hours, e.g. 2 seconds to 30 minutes.

During the melt blending, the temperature at which the polymers are combined in the blender will generally be in the range between the highest melting point of the polymers employed and up to about 100 IC above such melting point.

20 The time required for the melt blending can vary broadly and depends on the method of blending employed. The time required is the time sufficient to thoroughly mix the components. Generally, the individual polymers are blended for a time of about 10 seconds to about 15 minutes.

The polymer blends can contain additives such as stabilizers, anti-oxidants,  
25 anti-blocking agents, mold release agents, dyes, pigments, and flame retardants, as well as fillers and reinforcing agents, such as glass fibers, as long as the amounts and types do not interfere with the objectives of this invention.

The block copolymers and polymer blends prepared according to the invention are useful for the production of articles prepared by milling, extrusion, blow molding,  
30 or injection molding.

The following examples are presented to further illustrate the invention and are not meant to limit the scope thereby.

#### EXAMPLE I

The following example demonstrates the preparation of block copolymers and the combination of clarity and mechanical properties of various polymer blends.

Styrene/butadiene block copolymer (SB) was prepared employing a sequential solution polymerization under nitrogen. Polymerization runs were carried out in a stirred, 100 gallon carbon steel reactor with internal cooling coils employing essentially anhydrous reactants and conditions.

Lines were flushed with 0.5 kg cyclohexane following each charge. Polymerization was allowed to continue to completion after each monomer or monomer mixture charge. Polymerization temperature ranged from about 38.degree. to about 120° C. and pressure ranged from about 2 psig to about 60 psig. Total monomer weight was about 90 kg. The sequence of charges of tetrahydrofuran (THF), styrene (S), n-butyllithium initiator (i), butadiene/styrene mixture (B/S), and coupling agent (CA) was as follows.

##### Block Copolymer A1

0.5 THF, 0.05i<sub>1</sub>, 30S<sub>1</sub>, 0.05i<sub>2</sub>, 20S<sub>2</sub>, (5B<sub>1</sub>/10S<sub>3</sub>), (10B<sub>2</sub>/10S<sub>4</sub>), (10B<sub>3</sub> /55S<sub>5</sub>), CA. (amounts in parts/100 parts monomer)

##### Block Copolymer A2

0.1 THF, 0.05i<sub>1</sub>, 30S<sub>1</sub>, 0.05i<sub>2</sub>, 20S<sub>2</sub>, (5B<sub>1</sub>/10S<sub>3</sub>), (10B<sub>2</sub>/10S<sub>4</sub>), (10B<sub>3</sub> /55S<sub>5</sub>), CA. (amounts in parts/100 parts monomer)

Following completion of the sequential polymerizations, Vikoflex® 7170, (a coupling agent comprising epoxidized soybean oil sold by Viking Chemical Co.) was charged to the reactor. After completion of the coupling reaction, the reaction was terminated by adding CO<sub>2</sub> and 0.2 phm water. The styrene/butadiene block copolymers were stabilized with 0.25 phr (parts per hundred resin) Irganox® 1076 and 1.0 phr tris(nonylphenyl) phosphite. Vikoflex is a registered trademark of Viking Chemical Company. Irganox is a registered trademark of Ciba Geigy Corporation.

The block copolymers A1 and A2 exhibited melt flows of 7.2 and 6.5 g/10 min. respectively measured according to ASTM D-1238, condition G.

## EXAMPLE II

Polymer blends are formed by mixing and blending at least one tapered block  
5 copolymer made from styrene and butadiene, and at least one styrenic polymer made from styrene and methyl methacrylate. Nova 9203 and NAS 90, both copolymers of styrene and methyl methacrylate, available from Novacor Plastics Division were blended with at least one triple-tapered styrene-butadiene block copolymer at various weight ratios.

10 The results are summarized in Table 1. Blueness, tristimulus value "b", a measure of blue and yellow color, was measured with a HunterLab D25 M Optical Sensor using 15 mil extruded sheet (400° F/20 mil nominal die gap). Measurements were against a calibrated black background. A positive number represents yellow and a negative number represents blue. Haze in percent was measured according to  
15 ASTM 1003 on 15 mil sheets using a HunterLab ColorQuest instrument. Blueness was measured as described above. Other properties (notched Izod, flex yield etc) are measure by well-established and accepted ASTM or standard methods.

The copolymer used is a styrene/butadiene triple-tapered block copolymer employed. The styrenic polymer used is a copolymer of styrene and methyl  
20 methacrylate.



**Table 1 Physical properties of of polymer blends of triple-tapered block copolymer and styrene-methyl methacrylate copolymer**

Triple-tapered block copolymer (wt%)	100	80%	60%	50%	40%	30%	20%	10%
Styrene/MMA <sup>#</sup> copolymer (wt%)		20%	40%	50%	60%	70%	80%	90%
Melt Flow, (g/10 min)	10.9	9.1	6.8	5.1	4.8	4.2	3.0	2.4
ASTM D1238, Cond. G								
Density, (g/cc)	1.0182	1.0279	1.038	1.0431	1.0482	1.0533	1.0581	1.067
ASTM D792								
Tensile Elongation @ Break (%)	343	238	145	113	76	50	39	8
ASTM D638, 2" per min								
Tens. Yield Strength, (psi)	2,203	2,111	3,025	3,651	4,266	5,066	6,620	7,661
ASTM D638, 2" per min								
Flex Mod (Tan), (psi)	104,991	129,401	182,426	221,981	261,879	332,010	387,423	450,820
ASTM D790								
HDT, 66 psi (°C)	54	55	62	70	71	79	81	81
ASTM D648								
HDT, 264 psi (°C)	46	48	51	56	63	68	71	72
ASTM D648								
Vicat (°C)	60	62	74	80	87	92	93	93
ASTM D1545								
Shore D Hardness	61	65	69	72	75	78	81	85
ASTM D2240								
Izod Notched, (ft-lb/in)	15.4	17.2	14.3	3.7	0.39	0.27	0.25	0.36
ASTM D256, 1/8" thickness	Partial	Partial	Partial	Complete <sup>2</sup> Partial	Complete	Complete	Complete	Complete
Izod Unnotch, (ft-lb/in)			27.1			4.7	3.1	5.4
ASTM D256, 1/8" thickness	Non-Break	Non-Break	Complete <sup>4</sup> Non-Brk	Non-Break	Non-Break	Complete	Complete	Complete
Dynatup Tot. Enrgy (in-lb)	296	338	371	395	39.2	31.0	23.8	20.4
0.5" dia. Tup. 15 lbs, 30"								
Hunter Color, b	3.5	4.7	4.2	3.9	3.3	1.9	1.5	2.7
Haze, (%)	14.90	9.20	4.80	1.60	1.20	3.80	11.70	26.50
Light Transmission, (%)	89.5	83.7	84.1	85.9	88.3	91.0	91.8	90.0
*Tapered copolymer does not contain antiblock/impact modifier additive								

# Nova NAS 90 styrene-methyl methacrylate copolymer.

**Table 2 Injection molding properties of polymer blends of triple-tapered block copolymer and styrene-methyl methacrylate copolymer**

Triple-tapered block copolymer (wt%)	90	70%	60%	50%	40%	30%	20%	15%*
Styrene/MMA* copolymer (wt%)	10	30%	40%	50%	60%	70%	80%	80%
Flex yield (psi)	3394	3826	4538	5847	7610	9407	10466	11172
Tensile yield	2086	2155	-	3575	4326	5243	6515	6910
Tensile break	2744	2730	2833	3195	3588	4161	4812	5108
Notched Izod impact (ft-lb)	-	-	-	2.19	0.46	0.38	0.37	0.35
Unnotched Izod impact (ft-lb)	-	-	-	-	19.9	5.16	3.64	4.05
Haze (%)	19.2	21.0	15.6	11.23	5.7	2.37	0.78	0.93
Gloss (%)	129	126	126	137	142	143	154	154
Hunter Color (b)	4.54	4.70	4.49	4.12	3.44	2.69	1.79	1.48
Yellow Index	8.23	8.95	8.51	7.53	5.75	3.98	2.00	1.32
Light transmission (%)	86.5	84.3	84.0	85.5	87.9	90.2	91.9	92
Shore D hardness	63	67	69	72	75	78	81	82
Vicat °F	143	150	159	175	190	196	199	201

\* The blend contains 5 wt% of KR03 styrene-butadiene copolymer (commercial product of Chevron Phillips Chemical Company LP)

5 # Nova 9203 SMMA is used.

The results in Tables 1 and 2 demonstrate that polymer blends employing a block copolymer containing three tapered blocks exhibit a combination of good clarity and good impact toughness when the amount of the triple-tapered styrene-butadiene block copolymer is 50wt% or more, particularly 60 wt% or more of the total weight of the polymer blend.

The examples are for illustration purposes only. They are not intended to limited the scope of the present invention, which is defined by the written disclosure and the claims.

## CLAIMS:

1. A polymer blend comprising at least one coupled conjugated diene/monovinylarene block copolymer and at least one styrenic polymer, wherein

5 the coupled conjugated diene/monovinylarene block copolymer is produced by a process comprising sequentially contacting under polymerization conditions at least one monovinylarene monomer, an organoalkali metal initiator, at least one conjugated diene monomer, and thereafter coupling with a polyfunctional coupling agent to form the block copolymer;

10 at least three consecutive monomer mixture charges containing monovinylarene monomer and conjugated diene monomer are provided to produce at least three consecutive conjugated diene/monovinylarene tapered blocks in the block copolymer;

15 all the monovinylarene monomer and conjugated diene monomer contained in each charge are added at the beginning of the charge allowing excess of monomer to be present in the reactor;

the at least one monovinylarene monomer contains from 8 to 18 carbon atoms, and the at least one conjugated diene monomer contains from 4 to 12 carbon atoms, and

20 the styrenic polymer is selected from the group consisting of at least one copolymer produced by copolymerizing at least one styrenic co-monomer and at least one unsaturated oxygen or nitrogen containing co-monomer.

2. The polymer blend of claim 1 comprising

(A) 50 wt% or less of the styrenic polymer; and

25 (B) 50 wt% or more of the coupled conjugated diene/monovinylarene block copolymer.

3. The polymer blend of claim 2, wherein

the monovinylarene monomer is selected from the group consisting of styrene, 2-methylstyrene 3-methylstyrene, 4-methylstyrene, 4-ethylstyrene, 4-t-butylstyrene,  $\alpha$ -methylstyrene, and mixtures thereof; and

the conjugated diene monomer is selected from butadiene, isoprene, 2,3-dimethylbutadiene.

4. The polymer blend of claim 2, wherein

5 the styrenic co-monomer is selected from the group consisting of styrene, 2-methylstyrene 3-methylstyrene, 4-methylstyrene, 4-ethylstyrene, 4-t-butylstyrene,  $\alpha$ -methylstyrene, and mixtures thereof; and

10 the unsaturated oxygen or nitrogen containing co-monomer is selected from the group consisting of methyl acrylate, ethyl methacrylate, methyl acrylate, ethyl methacrylate, glycidyl acrylate, glycidyl methacrylate, acrylonitrile, and mixtures thereof.

5. The polymer blend of claim 2 comprising 60 wt% or more of the coupled conjugated diene/monovinylarene block copolymer.

6. The polymer blend of claim 3 comprising 60 wt% or more of the coupled conjugated diene/monovinylarene block copolymer.

15 7. The polymer blend of claim 4 comprising 60 wt% or more of the coupled conjugated diene/monovinylarene block copolymer.

8. The polymer blend of claim 7, wherein

20 the monovinylarene monomer is selected from the group consisting of styrene, 2-methylstyrene 3-methylstyrene, 4-methylstyrene, 4-ethylstyrene, 4-t-butylstyrene,  $\alpha$ -methylstyrene, and mixtures thereof; and

the conjugated diene monomer is selected from butadiene, isoprene, 2,3-dimethylbutadiene and mixtures thereof.

9. A polymer comprising at least one coupled conjugated diene/monovinylarene block copolymer and at least one styrenic polymer, wherein

25 the coupled conjugated diene/monovinylarene block copolymer is produced by a process comprising sequentially contacting under polymerization conditions at least one monovinylarene monomer, an organoalkali metal initiator, at least one conjugated diene monomer, and thereafter coupling with a polyfunctional coupling agent to form the block copolymer;

- at least three consecutive monomer mixture charges containing monovinylarene monomer and conjugated diene monomer are provided to produce at least three consecutive conjugated diene/monovinylarene tapered blocks in the block copolymer;
- 5 all the monovinylarene monomer and conjugated diene monomer contained in each charge are added at the beginning of the charge allowing excess of monomer to be present in the reactor;
- the at least one monovinylarene monomer contains from 8 to 18 carbon atoms, and the at least one conjugated diene monomer contains from 4 to 12
- 10 carbon atoms;
- the styrenic polymer is selected from the group consisting of at least one copolymer produced by copolymerizing at least one styrenic co-monomer and at least one unsaturated oxygen or nitrogen containing co-monomer; wherein
- 15 the monovinylarene monomer is selected from the group consisting of styrene, 2-methylstyrene 3-methylstyrene, 4-methylstyrene, 4-ethylstyrene, 4-t-butylstyrene,  $\alpha$ -methylstyrene, and mixtures thereof;
- the conjugated diene monomer is selected from butadiene, isoprene, 2,3-dimethylbutadiene and mixtures thereof;
- 20 the styrenic co-monomer is selected from the group consisting of styrene, 2-methylstyrene 3-methylstyrene, 4-methylstyrene, 4-ethylstyrene, 4-t-butylstyrene,  $\alpha$ -methylstyrene, and mixtures thereof; and
- the unsaturated oxygen or nitrogen containing co-monomer is selected from the group consisting of methyl acrylate, ethyl methacrylate, methyl
- 25 acrylate, ethyl methacrylate, glycidyl acrylate, glycidyl methacrylate, acrylonitrile, and mixtures thereof.
10. The polymer blend of claim 9 comprising 60 wt% or more of the coupled conjugated diene/monovinylarene block copolymer.
11. A polymer comprising at least one coupled conjugated diene/monovinylarene
- 30 block copolymer and at least one styrenic polymer, wherein

- the coupled conjugated diene/monovinylarene block copolymer is produced by a process comprising sequentially contacting under polymerization conditions at least one monovinylarene monomer, an organoalkali metal initiator, at least one conjugated diene monomer, and thereafter coupling with a polyfunctional coupling agent to form the block copolymer;
- at least three consecutive monomer mixture charges containing monovinylarene monomer and conjugated diene monomer are provided to produce at least three consecutive conjugated diene/monovinylarene tapered blocks in the block copolymer;
- all the monovinylarene monomer and conjugated diene monomer contained in each charge are added at the beginning of the charge allowing excess of monomer to be present in the reactor;
- the at least one monovinylarene monomer contains from 8 to 18 carbon atoms, and the at least one conjugated diene monomer contains from 4 to 12 carbon atoms;
- the styrenic polymer is selected from the group consisting of at least one copolymer produced by copolymerizing at least one styrenic co-monomer and at least one unsaturated oxygen or nitrogen containing co-monomer; wherein
- the polymer blend comprises 60 wt% or more of the coupled conjugated diene/monovinylarene block copolymer;
- the monovinylarene monomer is selected from the group consisting of styrene, 2-methylstyrene 3-methylstyrene, 4-methylstyrene, 4-ethylstyrene, 4-t-butylstyrene, and mixtures thereof;
- the conjugated diene monomer is selected from butadiene, isoprene, and mixtures thereof;
- the styrenic co-monomer is selected from the group consisting of styrene, 2-methylstyrene 3-methylstyrene, 4-methylstyrene, 4-ethylstyrene, 4-t-butylstyrene, and mixtures thereof; and

the unsaturated oxygen or nitrogen containing co-monomer is selected from the group consisting of methyl acrylate, ethyl methacrylate, methyl acrylate, ethyl methacrylate, and mixtures thereof.

12. A method of making a polymer blend, comprising blending at least one  
5 coupled conjugated diene/monovinylarene block copolymer and at least one styrenic polymer, wherein:

the coupled conjugated diene/monovinylarene block copolymer is produced by a process comprising sequentially contacting under polymerization conditions at least one monovinylarene monomer, an organoalkali metal  
10 initiator, at least one conjugated diene monomer, and thereafter coupling with a polyfunctional coupling agent to form the block copolymer;

at least three consecutive monomer mixture charges containing monovinylarene monomer and conjugated diene monomer are provided to produce at least three consecutive conjugated diene/monovinylarene  
15 tapered blocks in the block copolymer;

all the monovinylarene monomer and conjugated diene monomer contained in each charge are added at the beginning of the charge allowing excess of monomer to be present in the reactor;

the at least one monovinylarene monomer contains from 8 to 18 carbon atoms, and the at least one conjugated diene monomer contains from 4 to 12  
20 carbon atoms; and

the styrenic polymer is selected from the group consisting of at least one copolymer produced by copolymerizing at least one styrenic co-monomer and at least one unsaturated oxygen or nitrogen containing co-monomer.

- 25 13. The method of claim 12, wherein the polymer blend comprises:  
(A) 50 wt% or less of the styrenic polymer; and  
(B) 50 wt% or more of the coupled conjugated diene/monovinylarene block copolymer.

14. The method of claim 13, wherein:

the monovinylarene monomer is selected from the group consisting of styrene, 2-methylstyrene 3-methylstyrene, 4-methylstyrene, 4-ethylstyrene, 4-t-butylstyrene,  $\alpha$ -methylstyrene, and mixtures thereof; and

5 the conjugated diene monomer is selected from butadiene, isoprene, 2,3-dimethylbutadiene.

15. The method of claim 13, wherein:

the styrenic co-monomer is selected from the group consisting of styrene, 2-methylstyrene 3-methylstyrene, 4-methylstyrene, 4-ethylstyrene, 4-t-butylstyrene,  $\alpha$ -methylstyrene, and mixtures thereof; and

10 the unsaturated oxygen or nitrogen containing co-monomer is selected from the group consisting of methyl acrylate, ethyl methacrylate, methyl acrylate, ethyl methacrylate, glycidyl acrylate, glycidyl methacrylate, acrylonitrile, and mixtures thereof.

16. The method of claim 13, wherein the polymer blend comprises 60 wt% or  
15 more of the coupled conjugated diene/monovinylarene block copolymer.

17. The method of claim 14, wherein the polymer blend comprises 60 wt% or more of the coupled conjugated diene/monovinylarene block copolymer.

18. The method of claim 15, wherein the polymer blend comprises 60 wt% or more of the coupled conjugated diene/monovinylarene block copolymer.

20 19. The method of claim 18, wherein

the monovinylarene monomer is selected from the group consisting of styrene, 2-methylstyrene 3-methylstyrene, 4-methylstyrene, 4-ethylstyrene, 4-t-butylstyrene,  $\alpha$ -methylstyrene, and mixtures thereof; and

25 the conjugated diene monomer is selected from butadiene, isoprene, 2,3-dimethylbutadiene and mixtures thereof.



## INTERNATIONAL SEARCH REPORT

International Application No.

PCT/US 03/15654

A. CLASSIFICATION OF SUBJECT MATTER  
IPC 7 C08L53/02 C08F297/04

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 C08L C08F

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal

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X	EP 0 761 704 A (PHILLIPS PETROLEUM CO) 12 March 1997 (1997-03-12) page 6, lines 20-24; claims -----	1-19
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X	WO 01 25303 A (DOW CHEMICAL CO) 12 April 2001 (2001-04-12) page 9, lines 15-36; claims 1,3 -----	1
A	EP 1 029 876 A (ASAHI CHEMICAL IND) 23 August 2000 (2000-08-23) paragraphs '0013!', '0019! -----	1



Further documents are listed in the continuation of box C.



Patent family members are listed in annex.

## \* Special categories of cited documents:

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European Patent Office, P.B. 5818 Patentlaan 2  
NL - 2280 HV Rijswijk  
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,  
Fax: (+31-70) 340-3016

Authorized officer

Meulemans, R.

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Information on patent family members

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